

# Work Order ID 52001

September 11, 2009 9:56:43 AM



Page 1

Item ID:	D3884-2	Accept		Setup	Start	
Revision ID:	B				Stop	
Item Name:	Saddle, Inboard RH					
Start Date:	09/14/2009	Start Qty:	4.00	Cust Item ID:		
Required Date:	09/23/2009	Req'd Qty:	4.00	Customer:		
Reference:						

Approvals:	Process Plan:	<u>mf</u>	Date:	<u>09-09-11</u>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3884	B								

100

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Program Batch No. B52001

Double check by: mf

1-Machine Step No 1 per Folio FA819 and inspect per attached Dimension Sheets

2-Machine Step No 2 per Folio FA819 and inspect per attached Dimension Sheets

3-Machine Step No 3 per Folio FA819 and inspect per Dimension Sheets

mf  
09/10/30

2L 09/10/31

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

mf  
09/10/30

2L 09/10/31

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Item ID: D3884-2

Accept



Setup Start



Revision ID: B

Stop



Item Name: Saddle, Inboard RH

Start Date: 09/14/2009 Start Qty: 4.00



Cust Item ID:

Required Date: 09/23/2009 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

BF 09/10/31

(4)

130

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

BF 09-11-2

(4)

140

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME: 11:40  
OVEN TEMPERATURE: 320°  
FINISH TIME: 12:10

BF 09-10-2

(4)

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Item ID: D3884-2

Accept



Setup Start



Revision ID: B

Stop



Item Name: Saddle, Inboard RH

Start Date: 09/14/2009 Start Qty: 4.00



Cust Item ID:

Required Date: 09/23/2009 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

MO 09/11/02

24

160

Identify as per dwg &amp; Stock Location: 429

0.00



Packaging

Memo

0.00

Packaging

9/11/3

40 sf

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/11/03

MF 09-11-03

# Picklist Print

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Page 1

Work Order ID: 52001



Parent Item: D3884-2RevB



Parent Item Name: Saddle, Inboard RH

Start Date: 09/14/2009

Required Date: 09/23/2009

Comments:

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D6101-017RevB		Manufactured	No			100	Each	0.0000	4.0000			

Saddle Billet

D6101-017

Batch #  
B51835

X 4

mt  
09/10/30

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	52001
<b>Description:</b> Saddle, Inboard, RH		<b>Part Number:</b>	D3884-2
<b>Inspection Dwg:</b> D3884 <b>Rev.</b> B		<b>Page 1 of 1</b>	

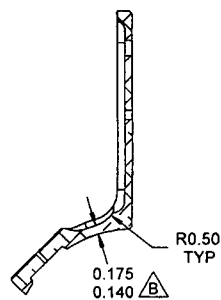
Inspect dimensions highlighted on inspection sheet drawing and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	2.870	2.880		2.875	2.875	2.875	2.875		
B	1.433	1.443		1.436	1.436	1.436	1.438		
C	0.638	0.658		.644	.644	.644	.646		
D	3.895	3.905		3.900	3.900	3.900	3.900		
E	0.257	0.262		.260	.260	.260	.258		
F	0.605	0.625		.613	.613	.613	.613		
G	1.120	1.130		1.125	1.125	1.125	1.125		
H	2.245	2.255		2.250	2.250	2.250	2.250		
I	2.000	2.020		2.008	2.008	2.006	2.006		
J	0.140	0.175		.158	.149	.155	.152		
K	1.265	1.285		1.268	1.268	1.268	1.269		
L	0.115	0.135		.125	.124	.125	.124		
M	0.240	0.260		.248	.251	.250	.249		
N	0.110	0.140		.140	.140	.140	.140		
O	0.240	0.260		.255	.252	.254	.252		
P	2.826	2.886		2.866	2.868	2.870	2.870		
Q	0.178	0.198		.188	.188	.188	.188		
R	0.140	0.165		.156	.155	.154	.152		
S	0.720	0.780		.750	.747	.750	.750		
T	1.220	1.280		1.265	1.260	1.269	1.255		
U	1.245	1.255		1.248	1.246	1.246	1.250		
V	5.990	6.010		6.000	6.000	6.000	6.000		
W	2.495	2.505		2.498	2.499	2.499	2.500		
X	0.490	0.510		.498	.498	.498	.498		
Y	0.020	0.040		.030	.030	.030	.030		
Z	0.313	0.318		.316	.316	.316	.316		
AA	0.760	0.765		.760	.760	.760	.760		
AB	0.215	0.220		.218	.218	.218	.218		
AC	0.316	0.321		.320	.320	.320	.320		
AD	1.745	1.755		1.746	1.748	1.745	1.750		
AE	0.990	1.010		1.003	1.005	1.005	1.001		
AF									
Accept/Reject									

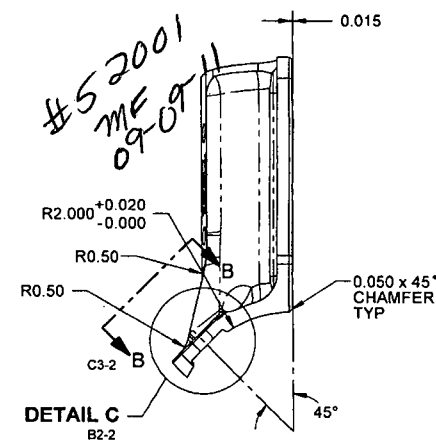
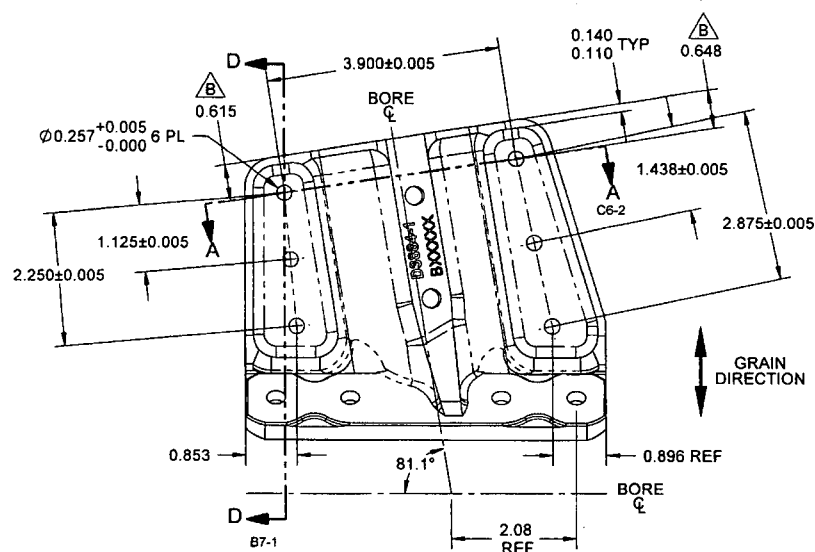
Measured by:	<i>[Signature]</i>
Date:	09/10/31

Audited by:	<i>[Signature]</i>
Date:	09/10/31

Rev	Date	Change	Revised by	Approved
A	09.10.22	New Issue	KJ	<i>[Signature]</i>



**SECTION D-D** B6-1



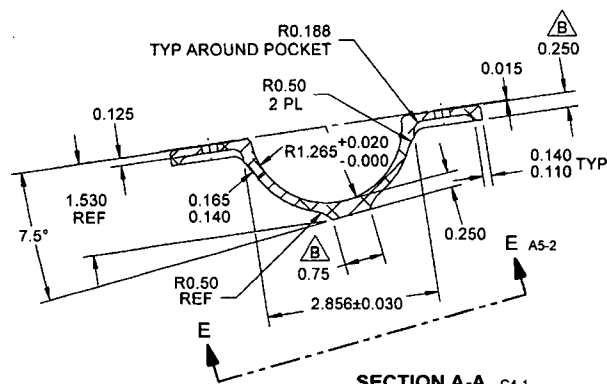
**RELEASED**  
06/15/14

**D3884-1 SADDLE, INBOARD LH (SHOWN)  
D3884-2 SADDLE, INBOARD RH (OPPOSITE)**

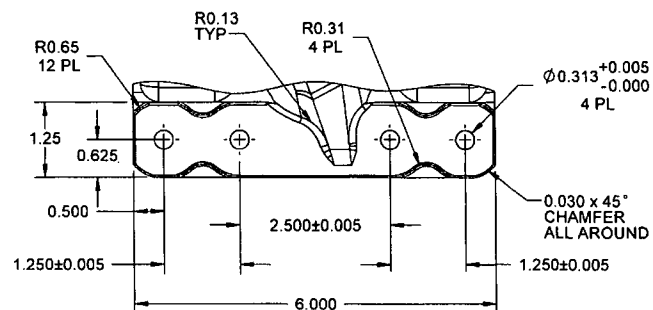
**NOTES:**

- 1) MATERIAL: 7075-T7351 ALUMINUM PER QQ-A-250/12 OR AMS-QQ-A-250/12 OR AMS-QQ-A-250/12 (REF DART SPEC. D6101-017)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX. DEPTH OF 0.010 WITH A MIN. TOOL RAD OF R0.010
- 7) WEIGHT: 0.71 lbs

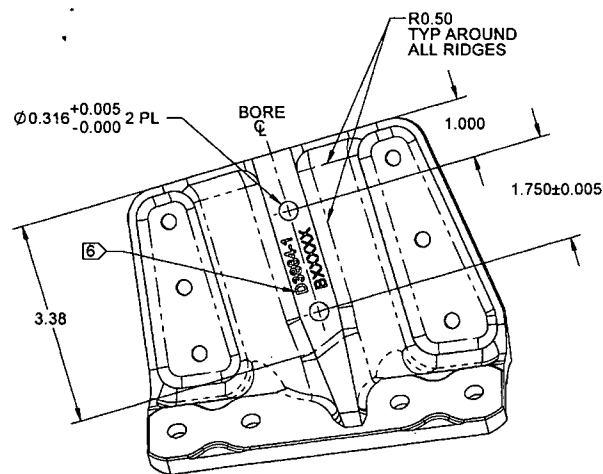
B	D6101-017 WAS D6102-017. ZN A6-1; ADD NOTE. ZN C4-2; ADD R0.031. ZN C2-2; INCREASED TOLERANCE 0.175 WAS 0.165. ZN B7-1; ADD 0.615. ZN C6-1; ADD 0.648. ZN C4-1; ADD 0.250. ZN D6-2; ADD 0.060. ZN C2-2; 0.75 WAS 0.65. ZN D7-2	RF	09.06.30
A	NEW ISSUE	RF	09.03.30
REV.	DESCRIPTION	BY	DATE
DESIGN	RF		
DRAWN	RF		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.06.30		
<b>DART AEROSPACE USA, INC.</b> PORT HADLOCK, WA DRAWING NO. <b>D3884</b> TITLE <b>INBOARD SADDLE</b> REV. B SHEET 1 OF 2 SCALE NTS <small>COPYRIGHT © 2009 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>			



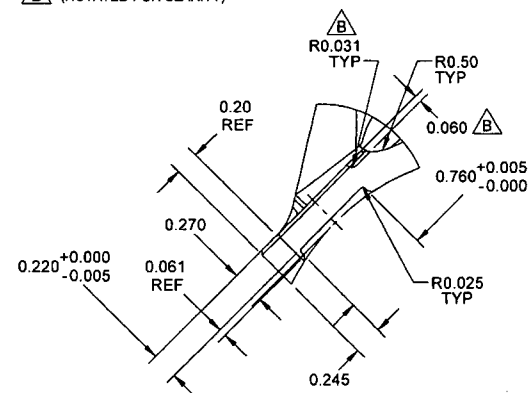
**SECTION A-A** C4-1



**VIEW B-B** B3-1  
(ROTATED FOR CLARITY)



**VIEW E-E** C6-2



**DETAIL C** B3-1  
SCALE 2X

**RELEASED**  
29/07/15/10

DESIGN	RF	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	PH	DRAWING NO.	REV. B
MFG. APPR.	PH	D3884	SHEET 2 OF 2
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	INBOARD SADDLE	NTS
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